



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-742-043
Job Sheet 196369



Part No: D412-742-043

Job Qty: 1 pcs

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 6/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Handfinish - 4 - Assembly	1 pcs	6/26/19		0.00	3.50	Handfinish - 4 - 1	ML 16-6-18
							Handfinish - 4 - 10	
							Handfinish - 4 - 11	
							Handfinish - 4 - 12	
							Handfinish - 4 - 13	
							Handfinish - 4 - 14	
							Handfinish - 4 - 15	
							Handfinish - 4 - 2	
							Handfinish - 4 - 3	
							Handfinish - 4 - 4	
							Handfinish - 4 - 5	
							Handfinish - 4 - 6	
							Handfinish - 4 - 7	
							Handfinish - 4 - 8	
							Handfinish - 4 - 9	
120	QC 5	1 pcs	6/26/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	DAS 81 9-89
							QC 5 - 24	DAS 68 9-89
							QC 5 - 3	JUN 26 2019
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	



Container No: S191349



Part: D412-742-043

Job No: 196369

Serial No/Batch: S191349

Revision: A/J

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 18/10/17, T6, STC SH05-

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

130 Packaging 3-1 - Stock - B4B 1 pcs	6/26/19	0.00 0.00	QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	DAS
			Packaging 3 - 6 - B4B	28
			Packaging 3 - 7 - B4B	9-89
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
135 DC - 1 - B4B 1 pcs	6/26/19	0.00 0.00	DC - 1 - B4B	21
			DC - 2 - B4B	28
140 QC 21 - FG 1 pcs	6/26/19	0.00 0.00	QC 21 - FG - 21	
			QC 21 - FG - 70	
			QC 21 - FG - 53	

Fg dock

Part Op 110 - (Assemble as per dwg) 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure Descriptions: tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 5163437
 Expiry date: 19-12-8 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex. A/R Sikaflex-241/-291 5163437 Expiry date: 19-12-8 3-Remove "T" pins once sikaflex is dry. 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon M133690 VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY
 BY: J.C DATE: 19/06/18
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D412-742-043
 Location: _____ PPP Rev: _____
 135 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	110-Handfinish - 4 - Assembly	5143675
AN3C6A	Bolt	4 Ea (4 ea)	110-Handfinish - 4 - Assembly	5174233
AN5C7A	Bolt	10 Ea (10 ea)	110-Handfinish - 4 - Assembly	5079115
D3391-021	Fwd Tube Assembly	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	6135195
D3391-023	Mid Tube Assembly	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5174645
D3391-025	Aft Tube Assembly	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5155257
D4095-041	Wearplate Fwd	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5072731
D4095-043	Wearplate Aft	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5072936
D4095-045	Wearplate Center	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5059995
NAS1149C0332R	Washer	28 Ea (28 ea)	110-Handfinish - 4 - Assembly	5158079
NAS1149C0532R	Washer	10 Ea (10 ea)	110-Handfinish - 4 - Assembly	5014735

Job Allocations

010432

Operation	Component Part	Required	Inventory	Allocated
110-Handfinish - 4 - Assembly	AN3C4A	24	790	0
	AN3C6A	4	201	0
	AN5C7A	10	102	0
	D3391-021	1	3	0
	D3391-023	1	5	0
	D3391-025	1	5	0
	D4095-041	1	10	0
	D4095-043	1	13	0
	D4095-045	1	5	0
	NAS1149C0332R	28	2,658	0
	NAS1149C0532R	10	204	0

Part Specifications

Specifications could not be found.

Plex 6/12/19 11:08 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐				Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐				Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐				Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)													
Description Work Order Deviation						Disposition													
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐						FAULT CATEGORY													
						Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐						Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐							
						Power Loss/Surge ☐ ☐ ☐ Follo/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐						Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐							
						Other/Details: _____													
Completed By						Lead hand / Supervisor													
QC / QA Coordinator																			